

Work Order ID 155255***155255***

Page 1

Thursday, January 12, 2017 11:29:48 AM

Item ID: 649.4817

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 1/16/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/19/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: JAN 12 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

649.4800

B

0.00

110

Waterjet

0.00

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

0.00

Quality Control

Memo

(2)

01/17/2017

(2)

01/17/2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 155255***155255***

Page 2

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N900040100

Setup Start

NS1

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NS2

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Start Date: 1/16/2017

Start Qty: 2.00

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

JAN 20 2017

160

Outsource process-Anodize per QSI017 4.1.10.1

0.00

160

Outsource4

Memo

0.00

Outsource process - Anodize

ISSUE P/O: **35094**
HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)

PRIME IAW MIL-P-23377J TYPE I CLASS N AS PER DWG. (SEE NOTE 2)

JAN 26 2017

170

Receive & Inspect for Damage & Mat'l Certs

0.00

170

Packaging

Memo

0.00

Packaging

2X **SP** **17-02-8**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Quality Control

Memo

0.00

*2.6 mils thickness**2*DAS
38
9-89
FEB 11 2017

210

Identify as per dwg & Stock Location: *CC6121* 0.00***210***

Packaging

Packaging

Memo

0.00

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

2

FEB 13 2017

DAS
6
9-89

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Quality Control

Memo

0.00

DAS
21
9-89

FEB 13 2017

ME
17-2-13

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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OTHER : _____																																																													

Picklist Print

Thursday, January 12, 2017 11:29:52 AM

Work Order ID: 155255

155255

Parent Item: 649.4817

649 4817

Parent Item Name: Shim

Start Date: 1/16/2017

Required Date: 1/19/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 16.08.11 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No				sf	74.1000		0.042105			

M2024T3S 050

2024-T3 .050 sheet

**

01/17/01/19

Location

Loc Qty

Loc Code

MAT022

74.100026

m131564

1.8

m134581

32.1

m135610

40.200026

05

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____					

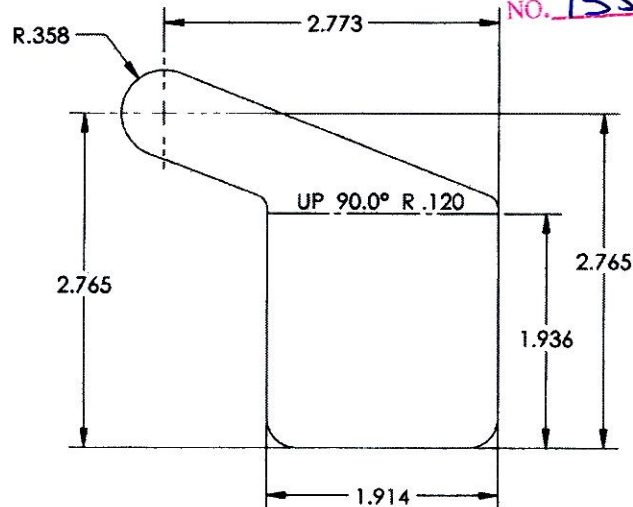
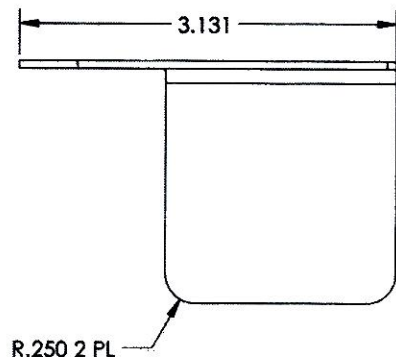
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NOTES: UNLESS OTHERWISE SPECIFIED

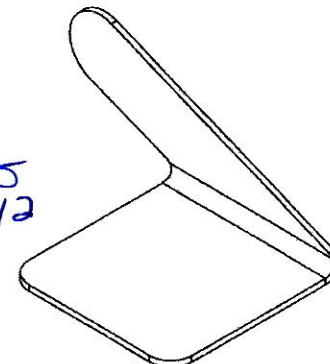
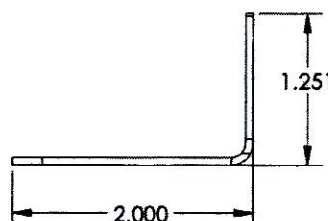
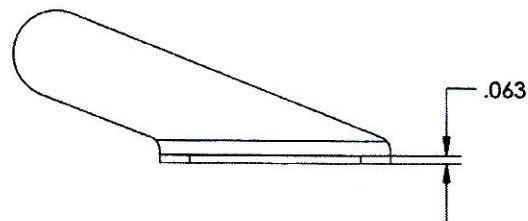
1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION 12PT. CENTURY GOTHIC.
5. PART DIMENSIONS CONTROLLED BY CAD MODEL: FILE NAME: 649.4816 DOUBLER.SLDPRT
6. INSPECTION DIMENSIONS SHOWN WITH FINISH APPROX. 3-5 MIL MAX PER FACE.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155255 MJS
17-01-12

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION PER		
N/C	INITIAL RELEASE	11-02-11	P. BRAVO
A	INCORPORATED ECH 03625	04-11-12	P. BRAVO
B	INCORPORATED ECH 03627	07-08-16	P. BRAVO



649.4811
FLAT PATTERN

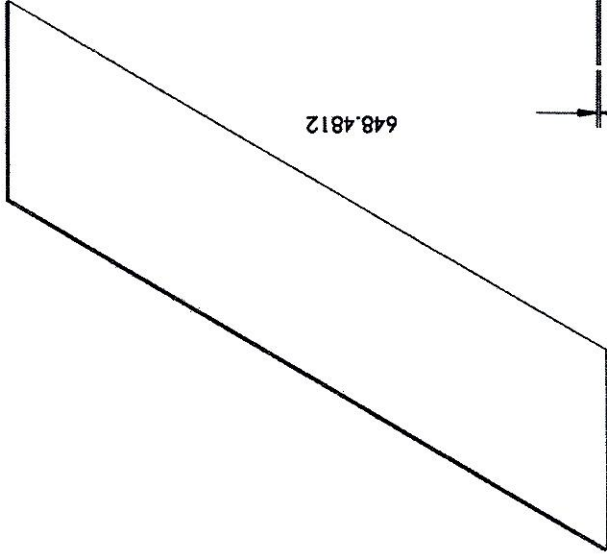
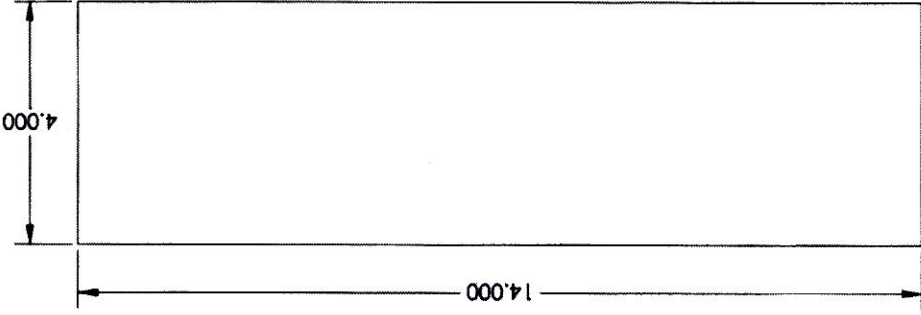


8	649.4817	SHIM	1	2
7	649.4816	DOUBLER	1	2
6	649.4815	SHIM	1	2
5	649.4814	DOUBLER	1	2
4	649.4813	SHIM	1	2
3	649.4812	SHIM	1	2
2	649.4811	CLIP	1	2
1		DELETED		
FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY	DESCRIPTION	PARTS LIST
NEXT ASSY (S)	ORIGINAL DATE 11-02-11	
649.4700	DRAWN BY A. QUINN	
	CHECKED BY P. BRAVO	
	DRAWING APPROVAL P. BRAVO	
	CONTRACT NO.	
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.02 3 PLACE DECIMALS ±.010 ANGLES ±.5°	
	SCALE NONE	

DART APICAL INDUSTRIES, INC. 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
SHEETMETAL	
REV. B	REV. B
87M26	649.4800
SHEET 1	OF 6

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648.4812

047

SHEETMETAL

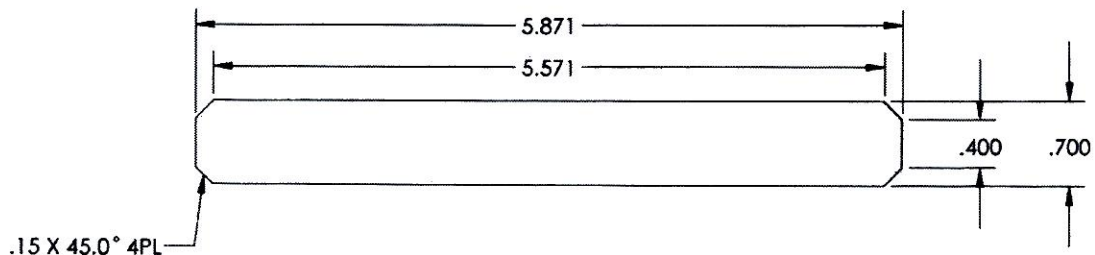
649.4800

SCALE NONE

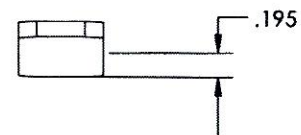
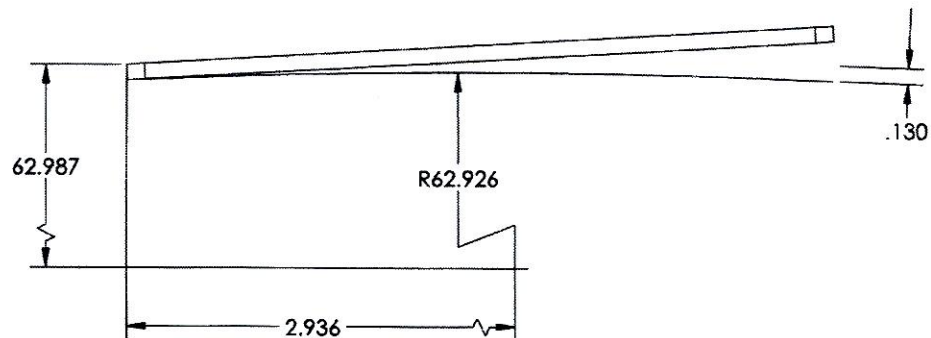
3 WALKER CHEMICALS LTD
ANGLOS & S

— — — — —

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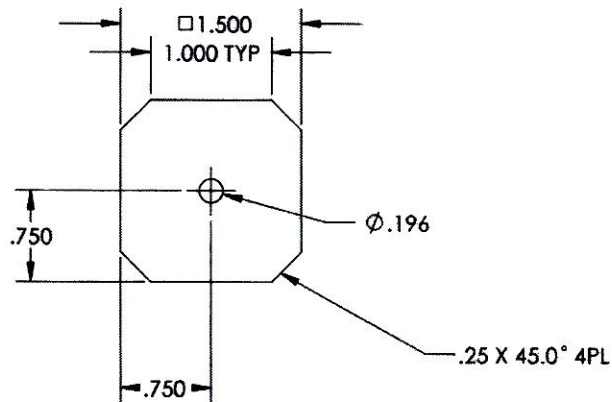
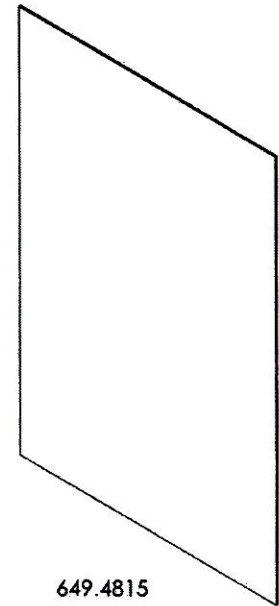
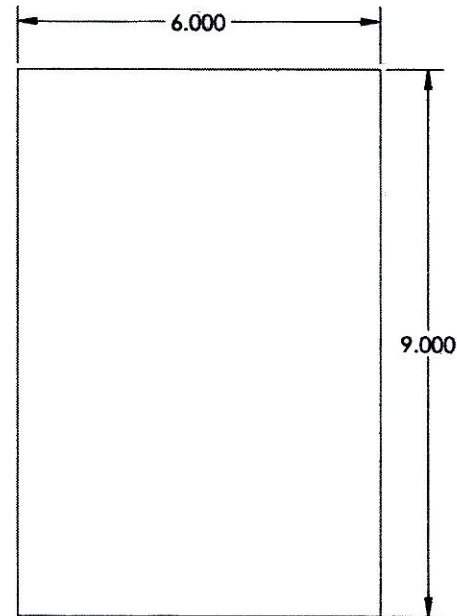
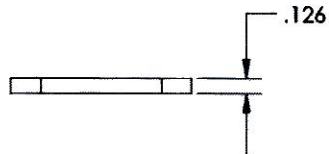
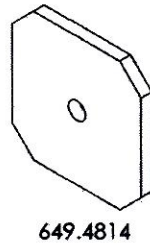


649.4813



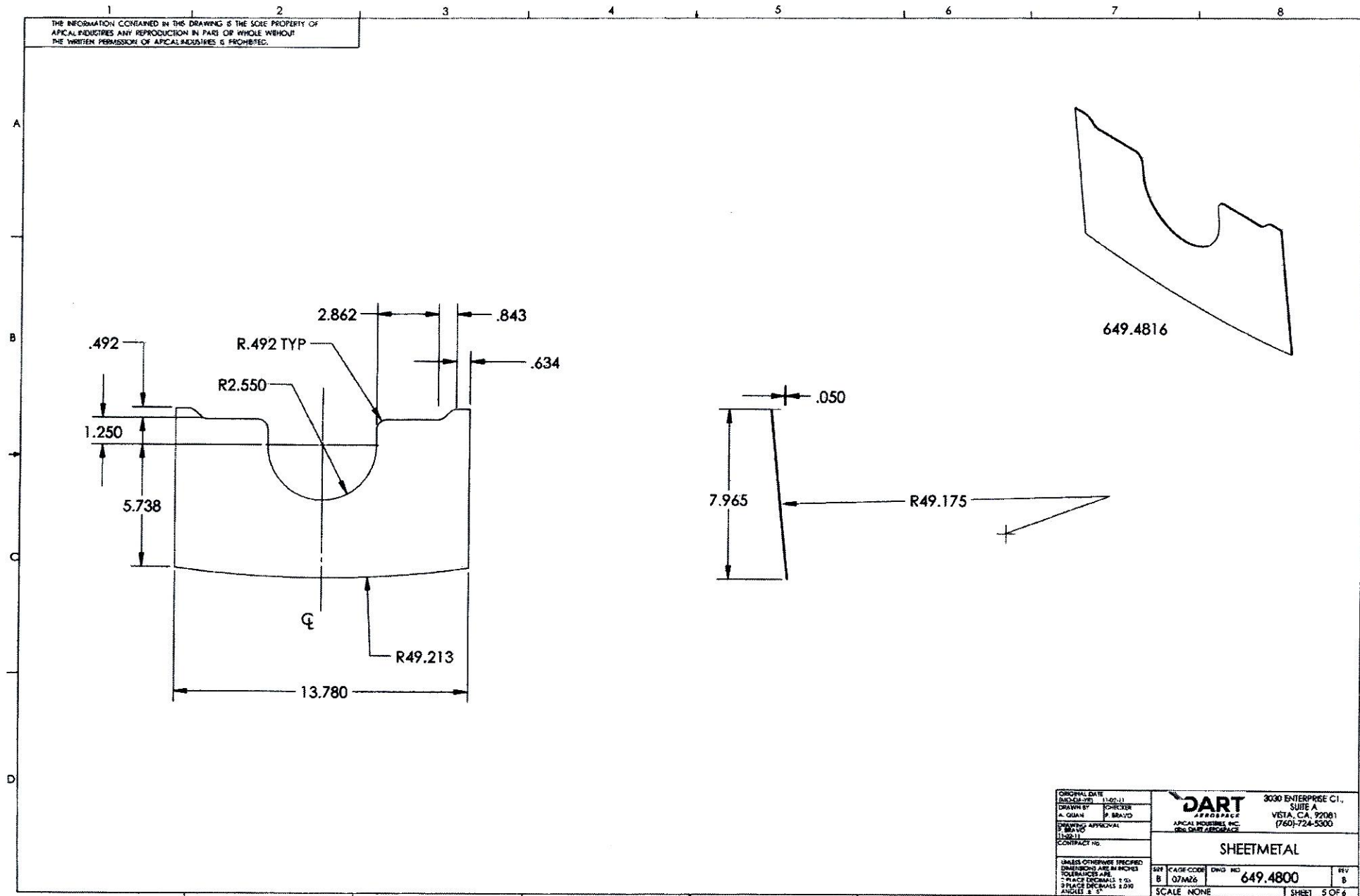
ORIGINAL DATE 11/02/11		3030 ENTERPRISE CT., SUITE A VISTA, CA, 92081 (760)-724-5300	
DRAWN BY A. CUSAN	CHECKED P. BRAND	DART AEROSPACE APICAL INDUSTRIES, INC. DART AEROSPACE	
DRAWING APPROVAL P. BRAND 11/02/11		SHEETMETAL	
CONTRACT NO.		SIZE B	REV. B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.03 2 PLACE DECIMALS ±.010 ANGLES ±.5°		CAGE CODE 07M26	DWG. NO. 649.4800
SCALE NONE		SHEET 3 OF 6	

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APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



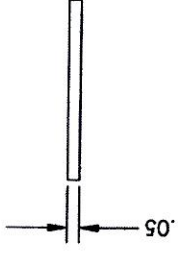
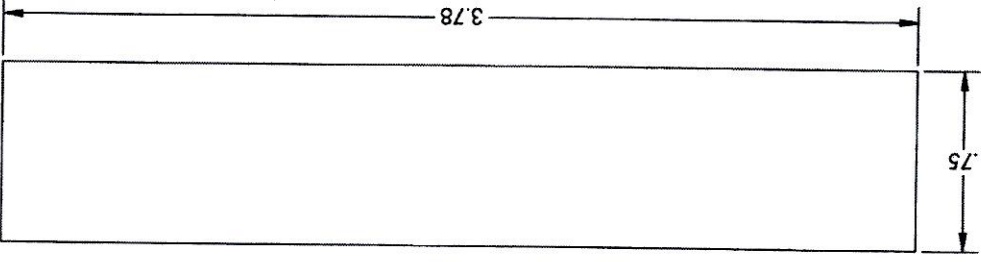
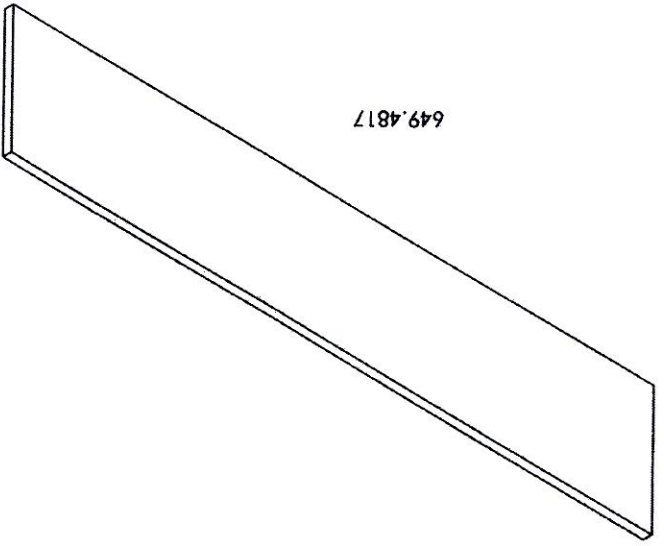
ORIGINAL DATE 11-02-11		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY A. CULAN		DART AEROSPACE	
CHECKED BY P. BRAVO		APICAL INDUSTRIES, INC. 8800 DART AEROSPACE	
DRAWING APPROVAL P. BRAVO 11-02-11		SHEETMETAL	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 7 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SHEET 8	REV. 8
CAGE CODE 07M26		PART NO. 649.4800	
SHEET 8		SHEET 4 OF 6	

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ORIGINAL DATE 11/05/11		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY A. GUAN	CHECKED P. BRAYO	APICAL INDUSTRIES, INC. DIN. DART ASSOCIATES	
DRAWING APPROVAL 11/02/11		SHEETMETAL	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: - PLACE DIMENSIONS 1/16" - PLACE DIMENSIONS 1/32" - PLACE DIMENSIONS 1/64" - ANGLES ± .5°		SHEET B	REV B
CASE CODE 07M26		DIN. NO. 649.4800	
SHEET 5 OF 6		REV B	

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



649.4817

SHEET 6 OF 6	
SCALE NONE	
DATE	649.4800
SIZE	8 1/2 X 11
DRWG. NO.	07/12/16
SHEETMETAL	
APICAL INDUSTRIES, INC. 17601-774-5300 VISTA, CA 92081 SUITE A	
3030 ENTERPRISE CT.	
DESIGNED BY: [blank]	
CHECKED BY: [blank]	
DRAWN BY: [blank]	
DATE: [blank]	
CONTRACT NO. [blank]	
REVISIONS: [blank]	
APPROVAL: [blank]	
DATE: [blank]	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35094**

Purchase Order Date 1/26/2017

PO Print Date 1/27/2017

Page Number 3 of 4

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

VENDOR'S TRUCK

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

Line Total:

\$107.00

6 155100

647.7810 BRACKET
REV. A

2/8/2017

6.00

\$14.50

\$87.00

Yes

2/8/2017

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377J TYPE I CLASS N

Line Total:

\$87.00

7 155101

647.7811 BRACKET
REV. A

2/8/2017

6.00

\$14.50

\$87.00

Yes

2/8/2017

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377J TYPE I CLASS N

Line Total:

\$87.00

8 155255

649.4817 SHIM REV. B

2/8/2017

2.00

\$6.25

\$12.50

Yes

2/8/2017

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377J TYPE I CLASS N

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

1/27/2017



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912919

Date: 07-Feb-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
ea	Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20663 PO: 35094 Line: 6		
6 ea	Part: 647.7811 Rev: A Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20664 PO: 35094 Line: 7		
2 ea	Part: 649.4817 Rev: B Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20665 PO: 35094 Line: 8		SP17-02-8
1 ea	Part: ADMINISTRATION FEE Rev: N/A ADMINISTRATION FEE Job: 20666 PO: 35094 Line: 9 Future PO's MIL-PRF-23377J has been changed since 2012 to Revision level K. Parts have been primed to Revision K.		
DATE: <u>07/02/2017</u>			
CERTIFIED SIGNATURE: <u>[Signature]</u>			
RECEIVER SIGNATURE: _____			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO			



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912919

Date: 07-Feb-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms

Ship Via

Quantity

Description

REQUIREMENTS.

MADE IN CANADA.

SP17-028